

Work Order ID 84278

84278

Page 1

Tuesday, May 08, 2012 4:11:05 PM

Item ID: D3245-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly *1X*
 Start Date: 5/8/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/11/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference: ECN 12-560 - **REWORK**

Approvals: Process Plan: *muf* Date: *12-05-08* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3245	Rev B

150 0.00

150

Small Fab

Small Fab

Memo

PULL FROM STOCK D3245-043 X 4 B78541

REMOVE STUDS AND GROMMETS AND DISCARD (2351-20-009-C3Y)

REPLACE WITH NEW STUDS
 2351-20-012-C3Y AND GROMMETS
 PER ECN 12-560

160 0.00

160

QC

Quality Control

Memo

0.00

Scrub 6/07

(1X)

JS 12/06/07

Work Order ID 84278

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Tuesday, May 08, 2012 4:11:05 PM

Item ID: D3245-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 5/8/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/11/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference: ECN 12-560

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location 233	0.00							
170									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

mf
12-06-08

Picklist Print

Tuesday, May 08, 2012 4:11:04 PM

Page 1

Work Order ID: 84278

Parent Item: D3245-043

Parent Item Name: Door Assembly

Start Date: 5/8/2012

Required Date: 5/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by:

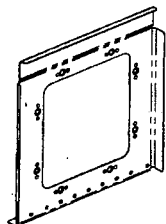
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
127H-35 HALF GROMMET		Purchased	No				Each	80.0000		32		5/12/06/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		72							
				119545		72							
				ST398		8							
				117203		5							
				118261		3							
2351-20-012-C3Y STUD		Purchased	No				Each	123.0000		32		5/12/06/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				399		100							
				121499		100							
				ST400		23							
				121237		23							
D3245-043 Door Assembly		Manufactured	No				Each	0.0000		4			

4/1X

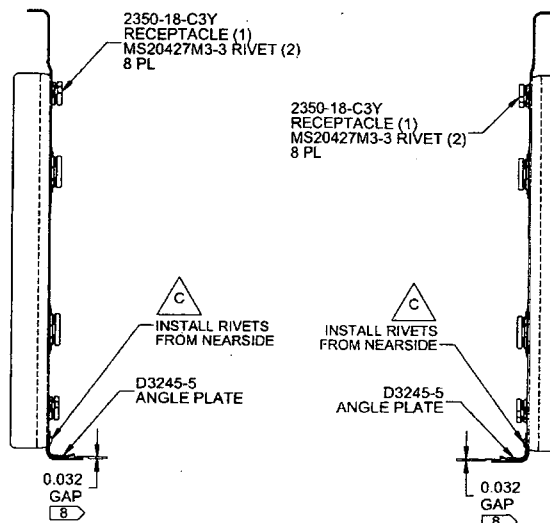
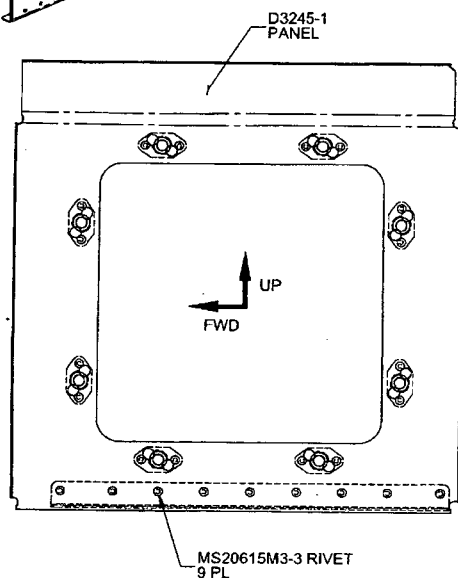
78541

ME

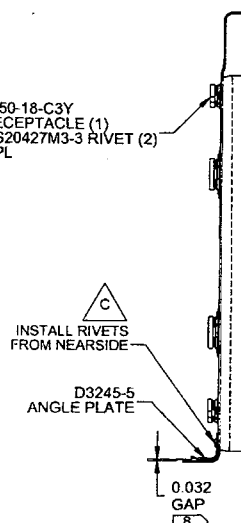
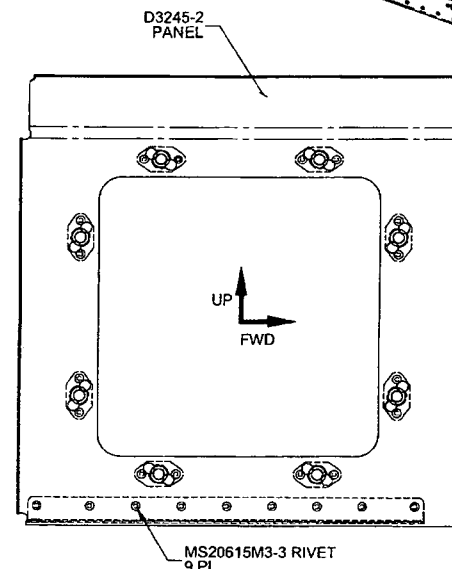
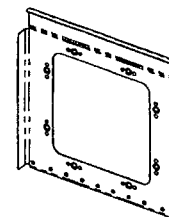
12-05-08



D3245-041 ACCESS PANEL ASSY (LH)



D3245-042 ACCESS PANEL ASSY (RH)



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
	1	D3245-2	PANEL
1		D3245-5	ANGLE PLATE
8		2350-18-C3Y	RECEPTACLE
16		MS20427M3-3	RIVET
9		MS20615M3-3	RIVET

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 0.83 lbs
 - 8) TEMPORARILY INSERT A 0.032" GAUGE-PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C		ADDED NOTE 8, SHEET 1: SPECIFIED RIVET ORIENTATION (B4-1, B5-1) CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D6-6). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165.		RP	12.04.11
B		REMOVE 0.0204 HOLES FROM D3245-1/1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION				BY DATE
DESIGN	RF				
DRAWN	MB				
CHECKED	A.P.				
MFG. APPR.	[Signature]				
APPROVED	[Signature]				
DE APPR.	[Signature]				
DATE	12.04.11				
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3245 TITLE ACCESS PANEL ASSY SCALE NTS SHEET 1 OF 7 REV. C COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

RELEASED 2012-05-07

H 84278

D3245-3 DOOR

2351-20-012-C3Y STUD
127H-35 GROMMET
8 PL



8.00
REF

8.00 REF

D3245-7 GASKET
REF

INSTALL D3245-7
GASKET ON THIS SIDE
B

D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD



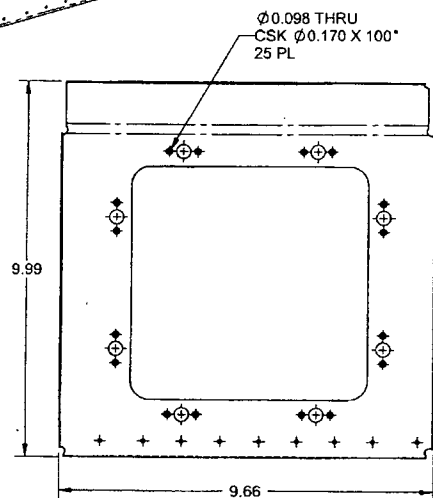
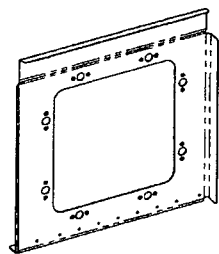
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

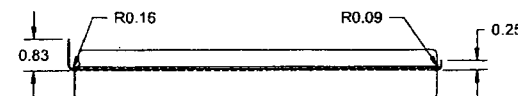
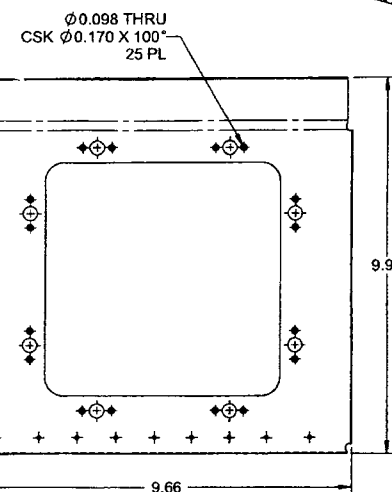
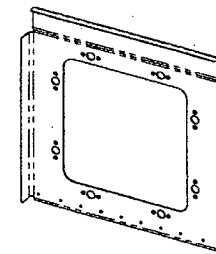
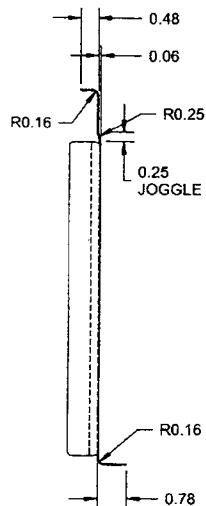
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2012-05-07

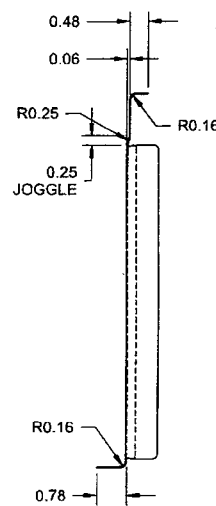
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DRAWN	MB		
CHECKED	AP	DRAWING NO. D3245	REV. C
MFG. APPR.	AP	SHEET 2 OF 7	
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DE APPR.	AP	ACCESS PANEL ASSY	NTS
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D3245-1 PANEL (LH)



D3245-2 PANEL (RH)



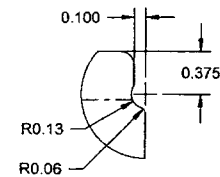
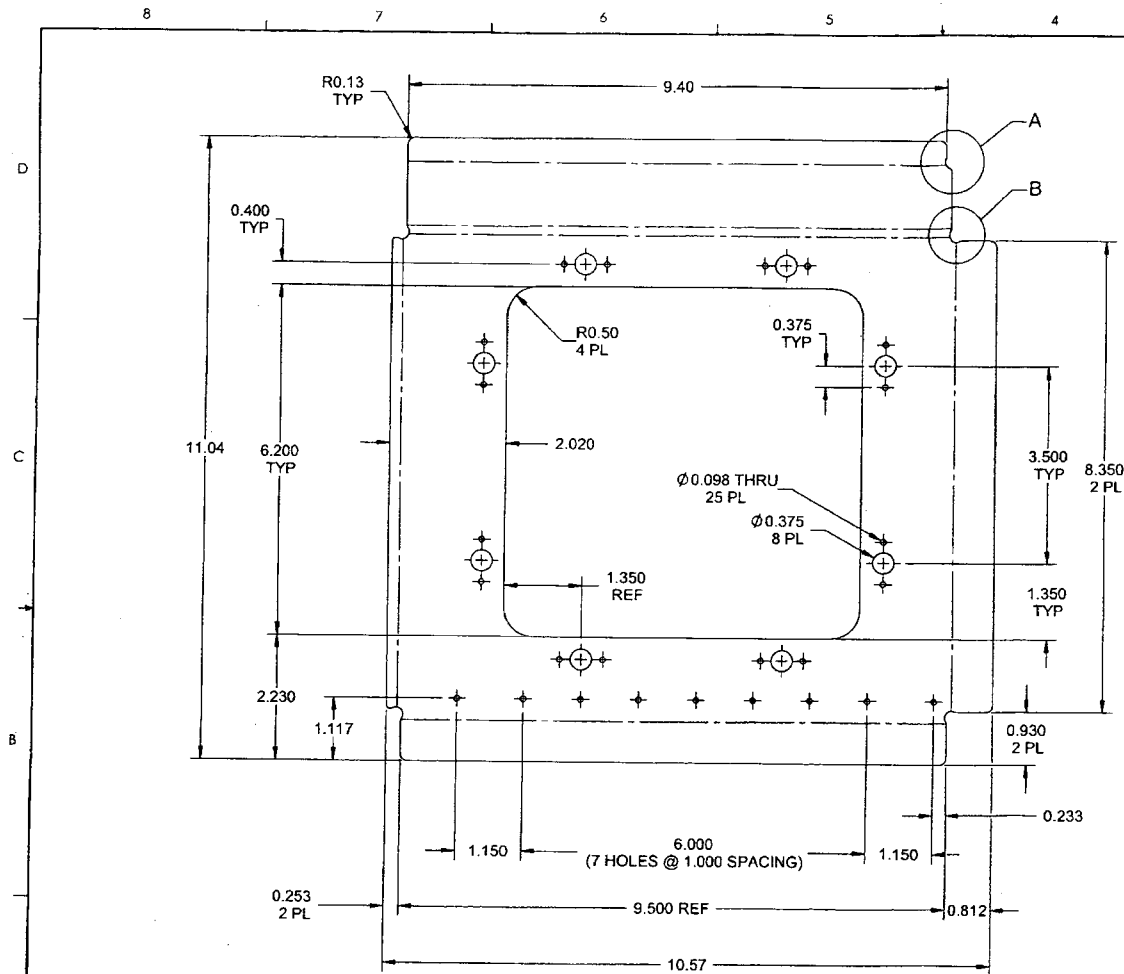
NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

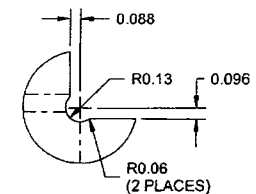
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DETAIL A: RELIEF
SCALE 1:1






DETAIL B: RELIEF
TYP. 4 PL
SCALE 1:1

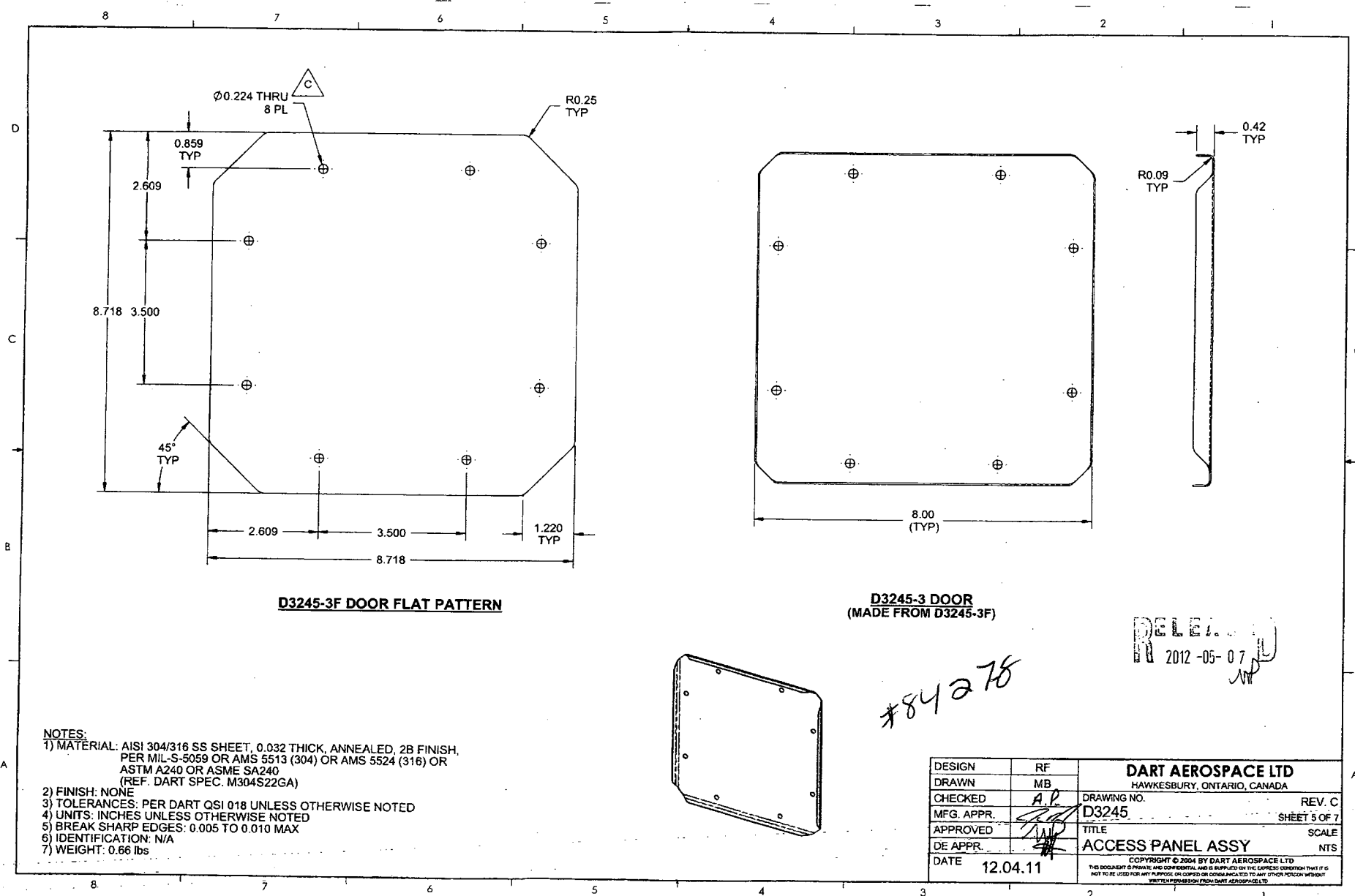
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2012-05-07
WMP

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 28 FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

D3245-1F PANEL FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.		D3245	SHEET 4 OF 7
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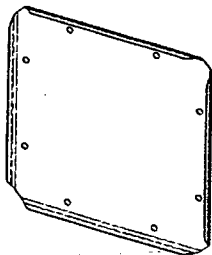
D3245-3F DOOR FLAT PATTERN

**D3245-3 DOOR
(MADE FROM D3245-3F)**

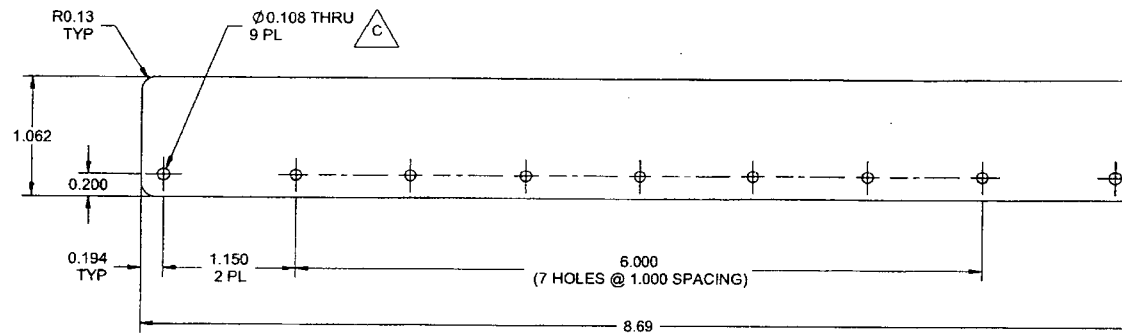
RELEASED
2012-05-07

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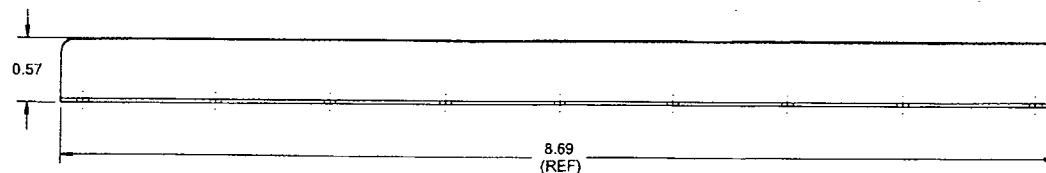
- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.66 lbs



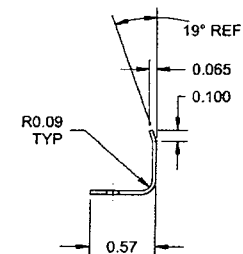
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D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



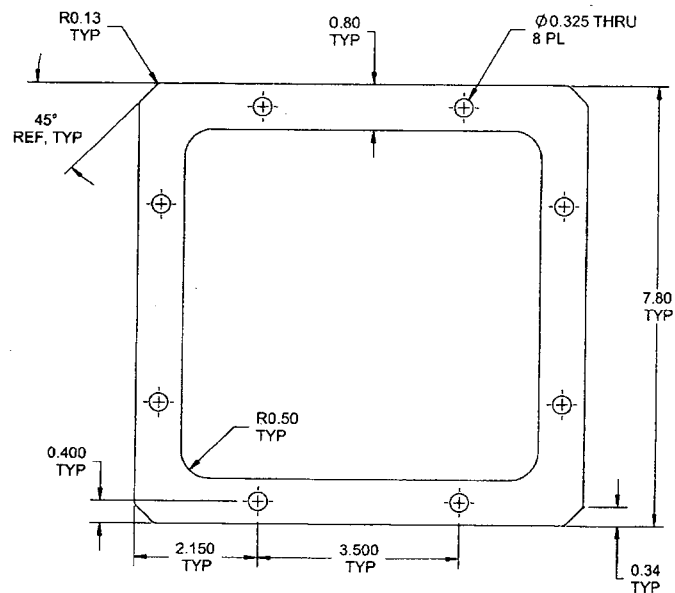
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2012-07-07

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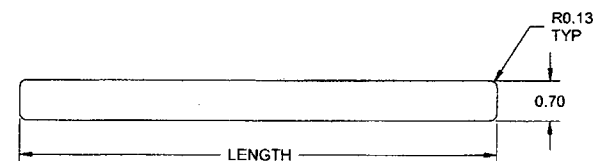
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

#64278

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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

2012-05-07

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MFG. APPR.	<i>MB</i>	D3245	SHEET 7 OF 7
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